












Date: Wednesday, 11/03/2009 12:58:56 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 46438		
Estimate Number	: 11041		
P.O. Number	:	Part Number	: D2809
This Issue	: 11/03/2009 S.O. No. :	Drawing Number	: D2809 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 40929	Material	:
Written By	:	Due Date	: 20/03/2009 Qty: 40 Um: Each
Checked & Approved By	: <u>JUD 09.03.11</u>		
Comment	: Est C 02.03.07 Now turned in house NG		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
			
Comment: Qty.: 0.1045 f(s)/Unit Total : 4.1790 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: <u>M110532</u> <u>SA 09/03/15</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204			
<div style="text-align: right;"> <u>SA 09/03/15</u> 40 </div>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 09/03/15</u> 40			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SA 09/03/15</u> 40			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr all sharp edges as per dwg <u>SA 09/03/15</u> 40			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:56 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46438

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/03/17

7.0

POWDER COATING

POWDER COATING



m110939

Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

(40)

START TIME:

9:15

OVEN TEMPERATURE:

320°

FINISH TIME:

10:45

cmd/FL

09/03/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-18

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(40)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

99

9/3/20

SL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

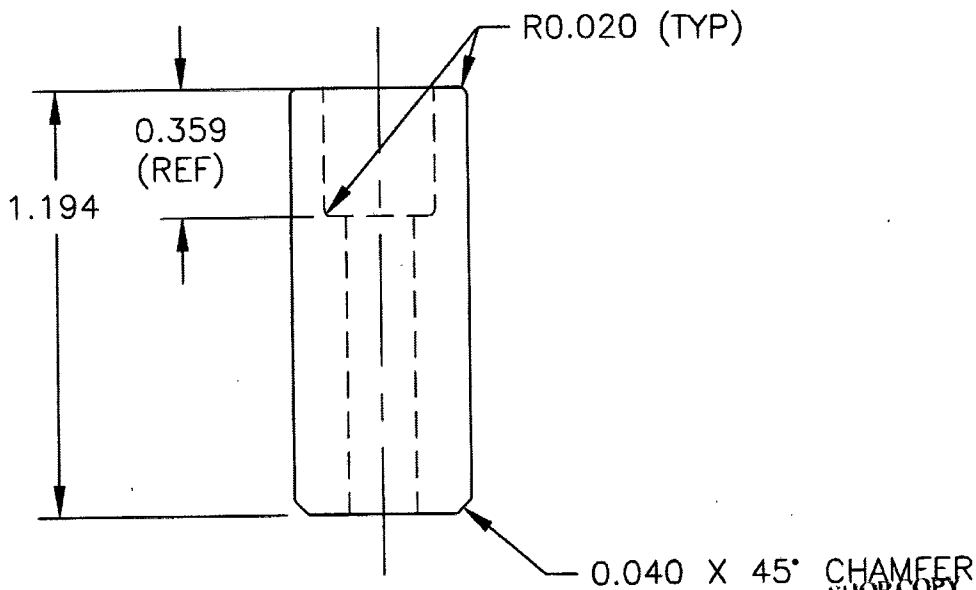
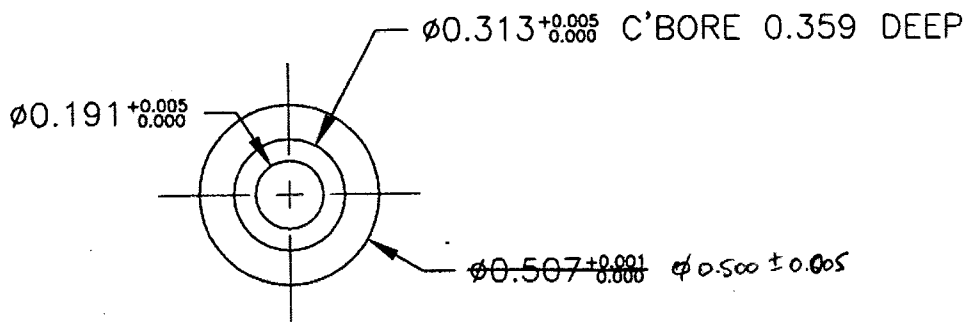
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01.04.26	ADD POWDER COAT ; $\phi 0.500$ WITH $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40438

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PER DART QSI 005 4.3